

Date: Wednesday, 18/06/2008 1:26:47 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 39922	
Estimate Number : 10279	
P.O. Number :	Part Number : D3121143
This Issue : 18/06/2008 S.O. No. :	Drawing Number : D3121 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 39014	Material :
Written By :	Due Date : 11/07/2008 Qty: 9 Um: Each
Checked & Approved By : JLD 08.6.18	
Comment : Est Rev: Pick: A 04.02.18 New issue KJ/DS Est Rev: B ECN 1060 07-11-12 DD verified by: EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174B1000X02000	17-4 SS Bar
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Comment: Qty.: 0.3864 f(s)/Unit Total : 3.0912 f(s)
 Material: 17-4 SS Bar per AMS 5604/5643
 (M17-4-B1.000x02.000)
 Identify for D3121-113
 Batch: M108595

88 08/07/27

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: (1.000" x 2.000") 4.425" long

88 08/07/27

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-113 as per Folio FA330 and Dwg D3121
 Identify as D3121-113

2-Deburr

3-Scribe batch number

88 08/07/27 (7)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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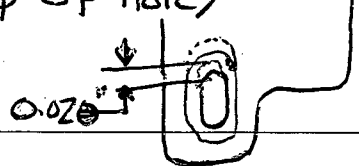


Comment: INSPECT PARTS AS THEY COME OFF MACHINE

88 08/07/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3121-143 PAR #: 08-024 Fault Category: Prod / Machine Part NCR: Yes ☒ No ☐ DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/27	3.0	one part all the slot are off by .020" R.C Jig problems will re-machine jig.	CP 08.07.28 pw	PAR 08-024 Re-MANUFACTURE FIXTURE Re-run hole & C'SINK to add 0.020" to top of holes	S.S 08/07/28 08.07.28	S 08/07/28	CP 08.07.28 pw QSI042	S 08/07/28
			QSI042		S.S 08/07/28	S 08/07/28	08.07.28	S 08/07/28

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 1:26:47 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 39922

Part Number: D3121143

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 08/07/31

6.0

D312121

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3121-21

Bolt

18 339947 x 18

AS 08/08/01

7.0

D3121241

Bearing Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3121-241 Bearing Ass

39226 x 12 40352 x 6

AS 08/08/01

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3121-143 as per Dwg D3121.

AS 08/08/01 (9)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS 08/08/01 (9)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST233

AS 08/08/01 (9)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/08/07

Job Completion



MF 08-08-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/8/01		During Assembly of the D3121-21 Bolt Broke in hole. R.C. hole was not taped all the way.	<i>[Signature]</i>	Drill out Broken bolt and re tap. Scrap and Replace bolt D3121-21 B# B39947	<i>[Signature]</i> 08/08/01	<i>[Signature]</i> 08/08/01	<i>[Signature]</i>	<i>[Signature]</i> 08/08/01
				Qty (40)				

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39922
Description: Bracket		Part Number: D3121-113
Inspection Dwg: D3121	Rev: E	Page 1 of 2

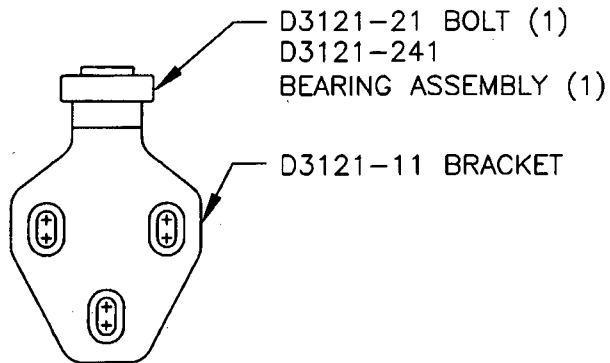
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

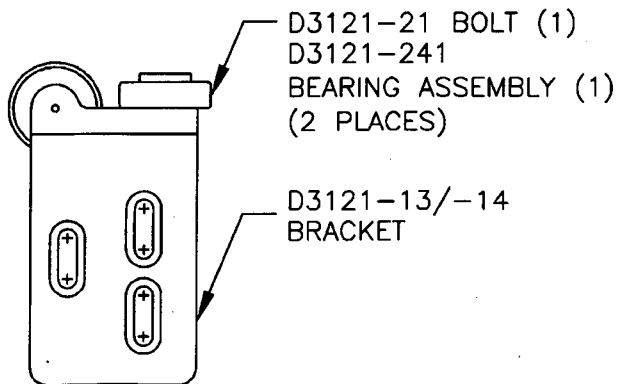
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	0.080	✓			
0.300	+/-0.010	0.299	✓			
R0.375	+/-0.010	0.375	✓			
1.54	+/-0.030	1.540	✓			
0.350	+/-0.010	0.353	✓			
R0.25	+/-0.030	0.250	✓			
Ø0.392	+0.002/-0.000	0.393	✓			
Ø0.201	+0.005/-0.000	0.206	✓			
2.540	+/-0.010	2.543	✓			
1.590	+/-0.010	1.593	✓			
0.160	+/-0.010	0.162	✓			
0.400	+/-0.010	0.400	✓			
1.220	+/-0.010	1.221	✓			
1.600	+/-0.010	1.605	✓			
3.80	+/-0.030	3.798	✓			
1.800	+/-0.010	1.803	✓			
R0.50	+/-0.030	0.500	✓			
0.130	+/-0.010	0.125	✓			
3.41	+/-0.030	3.400	✓			
3.65	+/-0.030	3.650	✓			
2.24	+/-0.030	2.220	✓			
45°	+/-0.1°	45°	✓			
R0.25	+/-0.030	0.250	✓			
3.97	+/-0.030	3.971	✓			
R0.38	+/-0.030	0.380	✓			
Ø0.392	+0.002/-0.000	0.393	✓			
Ø0.201	+0.005/-0.000	0.206	✓			
0.268	+/-0.010	0.268	✓			
R0.260	+/-0.010	0.260	✓			
0.080	+/-0.010	0.078	✓			
0.300	+/-0.010	0.297	✓			
0.381	+/-0.010	0.381	✓			
0.201	+/-0.010	0.204	✓			
0.580	+/-0.010	0.580	✓			

DART

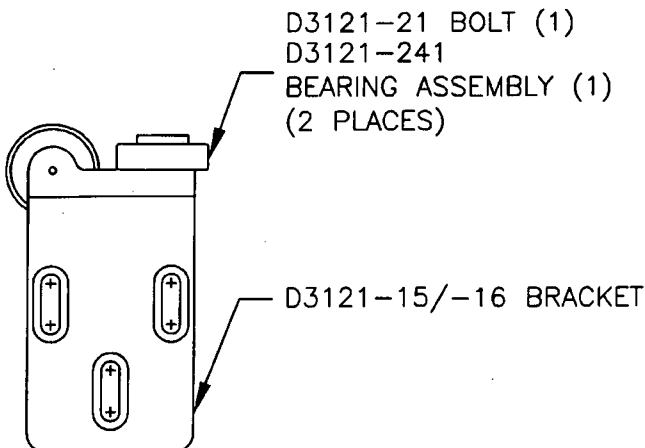
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

RELEASED
07.11.07

D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-35/-36)

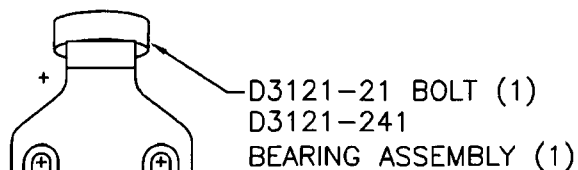
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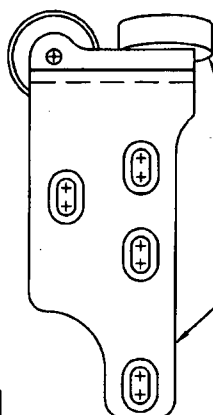
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 2 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-111 BRACKET

D3121-141 BRACKET ASSEMBLY

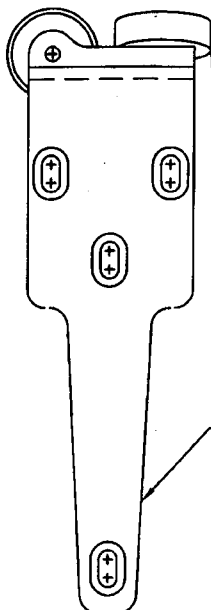
(REPLACES PREMIER P/N B30-23001-01)

RELEASED
07.11.07

D3121-113/-114 BRACKET

**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-03/-04)

D3121-115/-116
BRACKET**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-05/-06)

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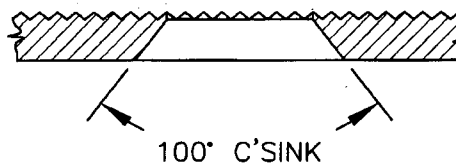
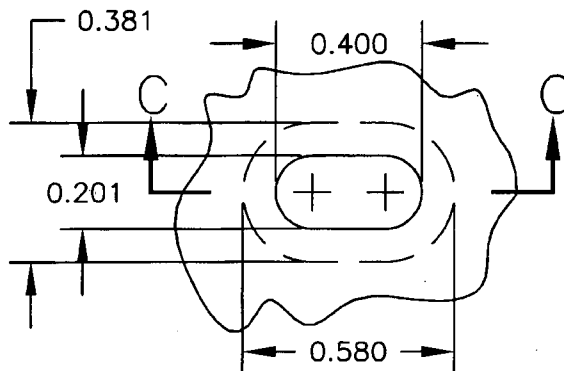
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

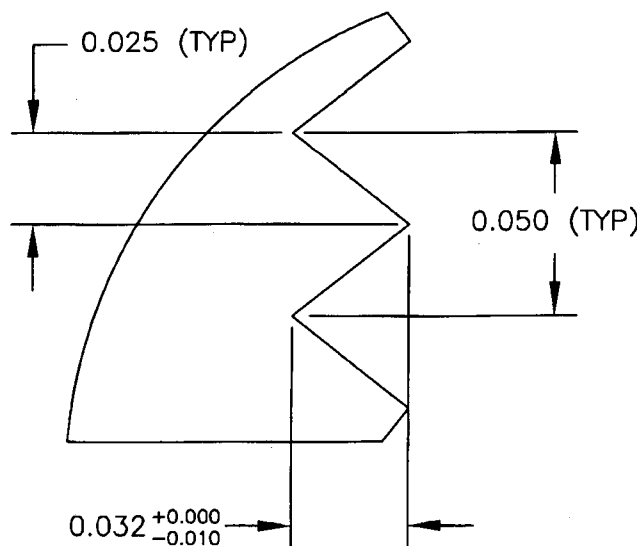
DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



SECTION
C-C

RELEASED
07.11.07

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



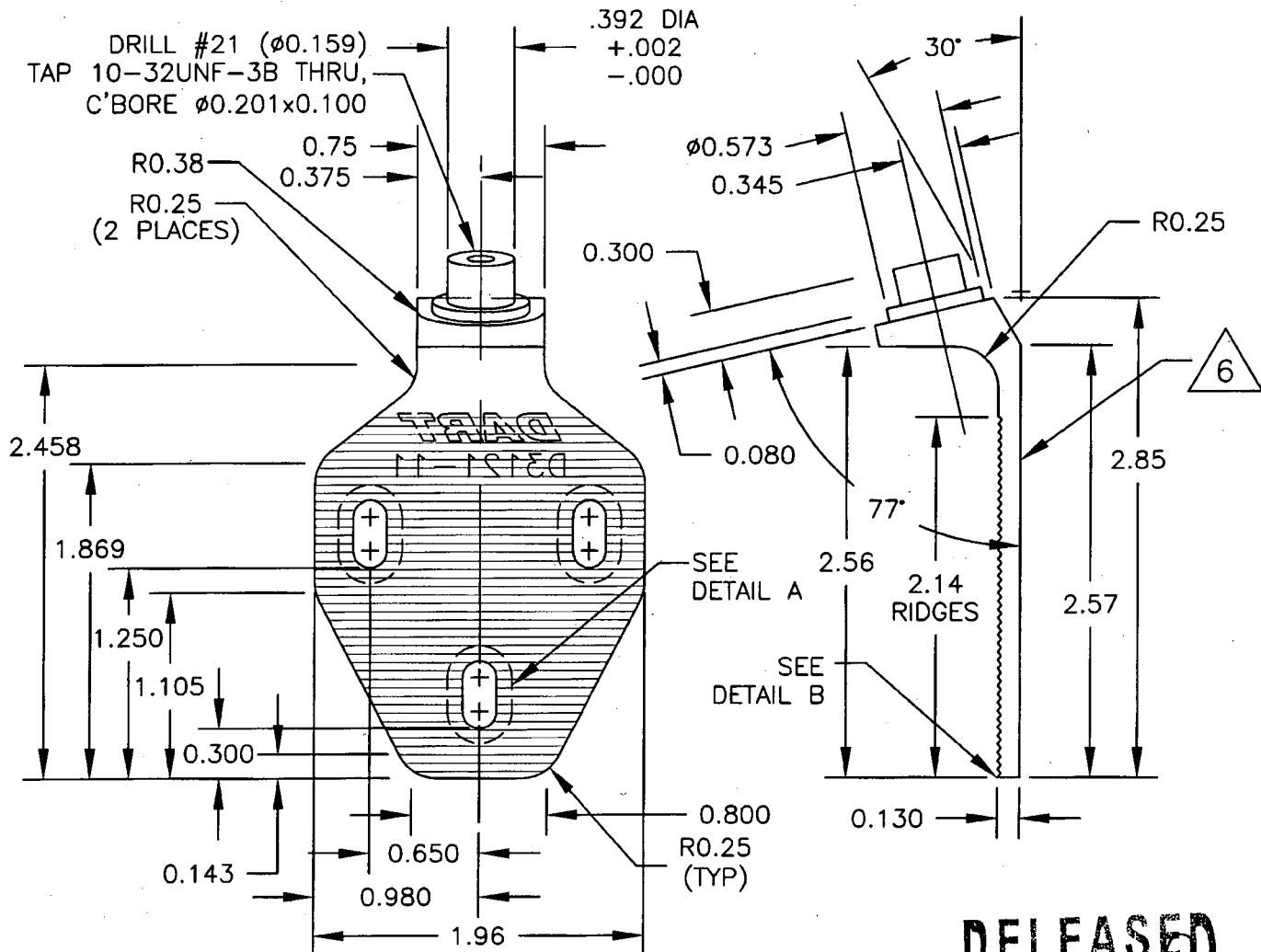
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DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1

**RELEASED**
07.11.07**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

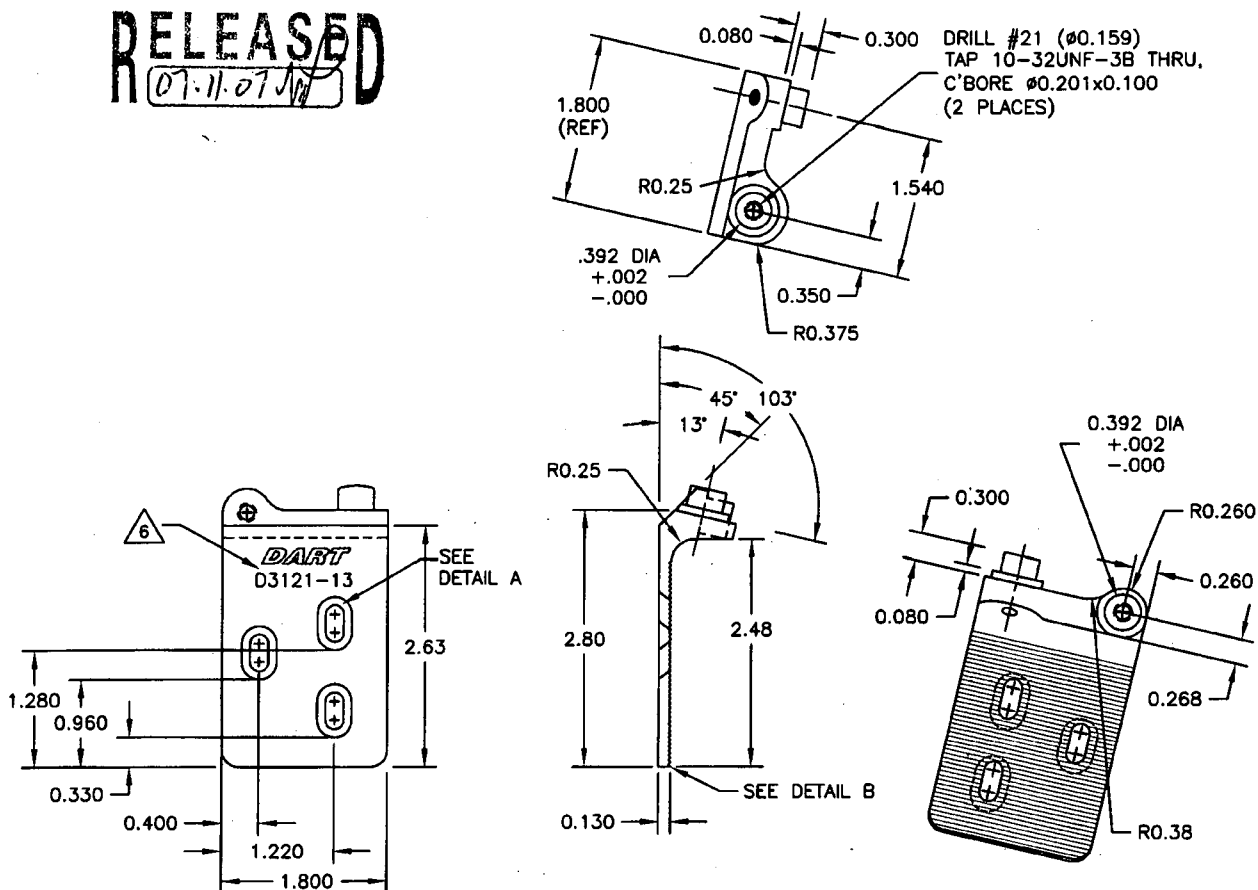
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07

D3121-13 BRACKET (SHOWN)
D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

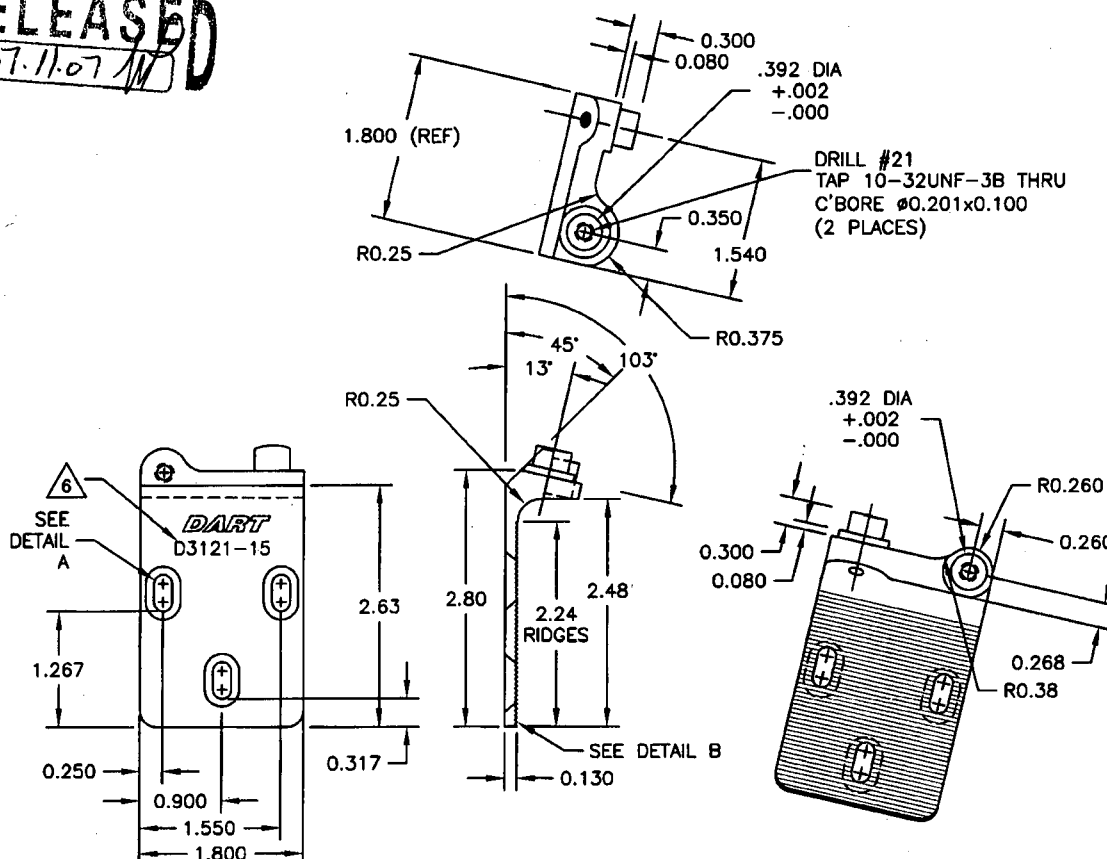
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

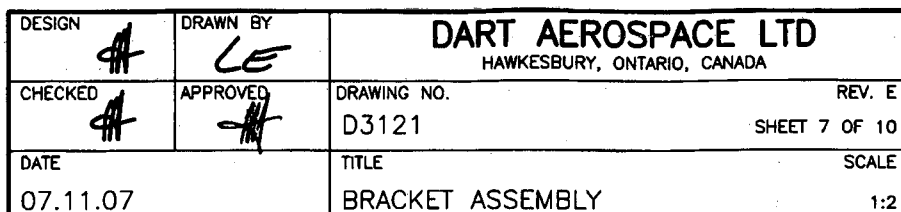
RELEASED
07.11.07**D3121-15 BRACKET (SHOWN)****D3121-16 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

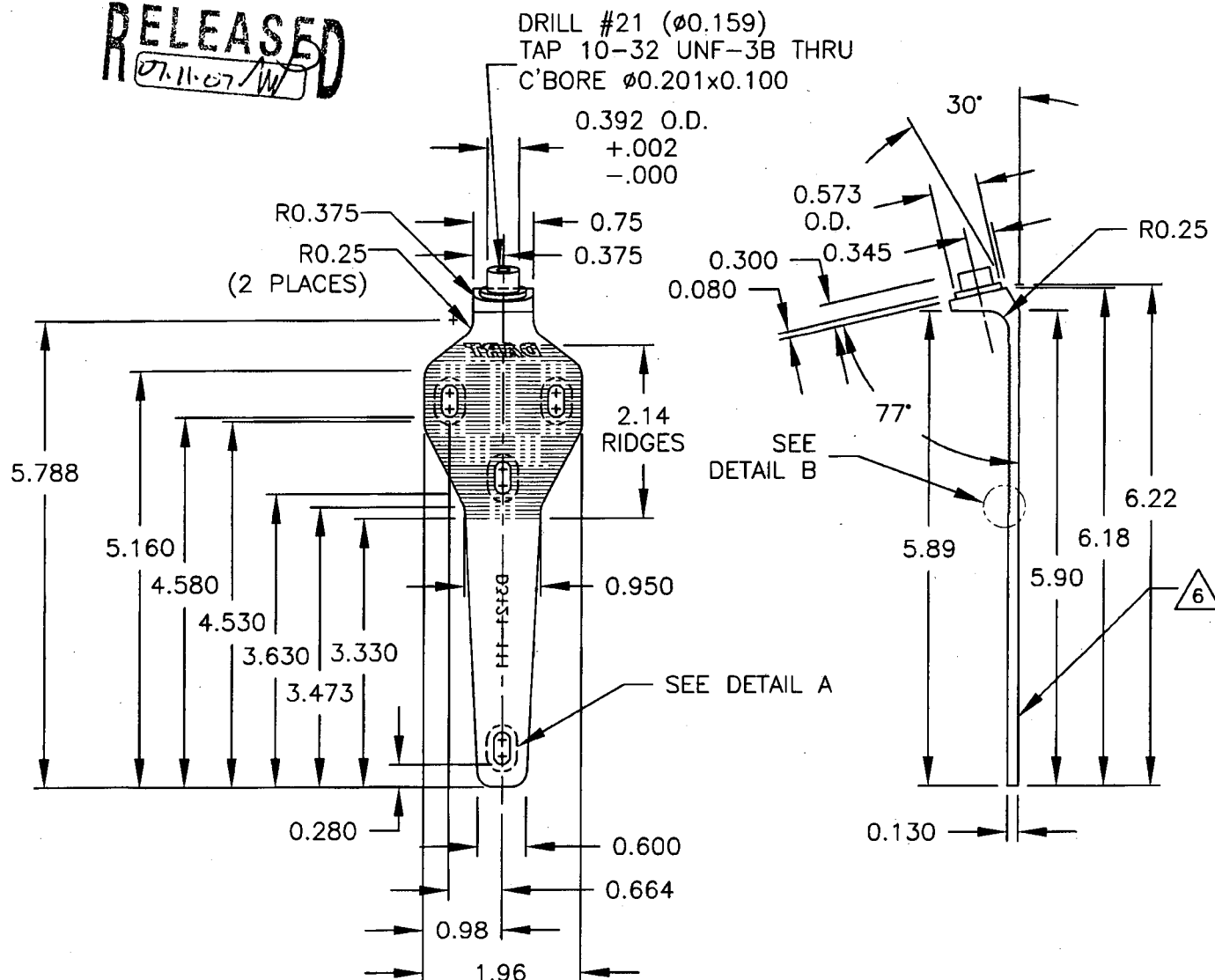
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RELEASED
07.11.07/W



- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

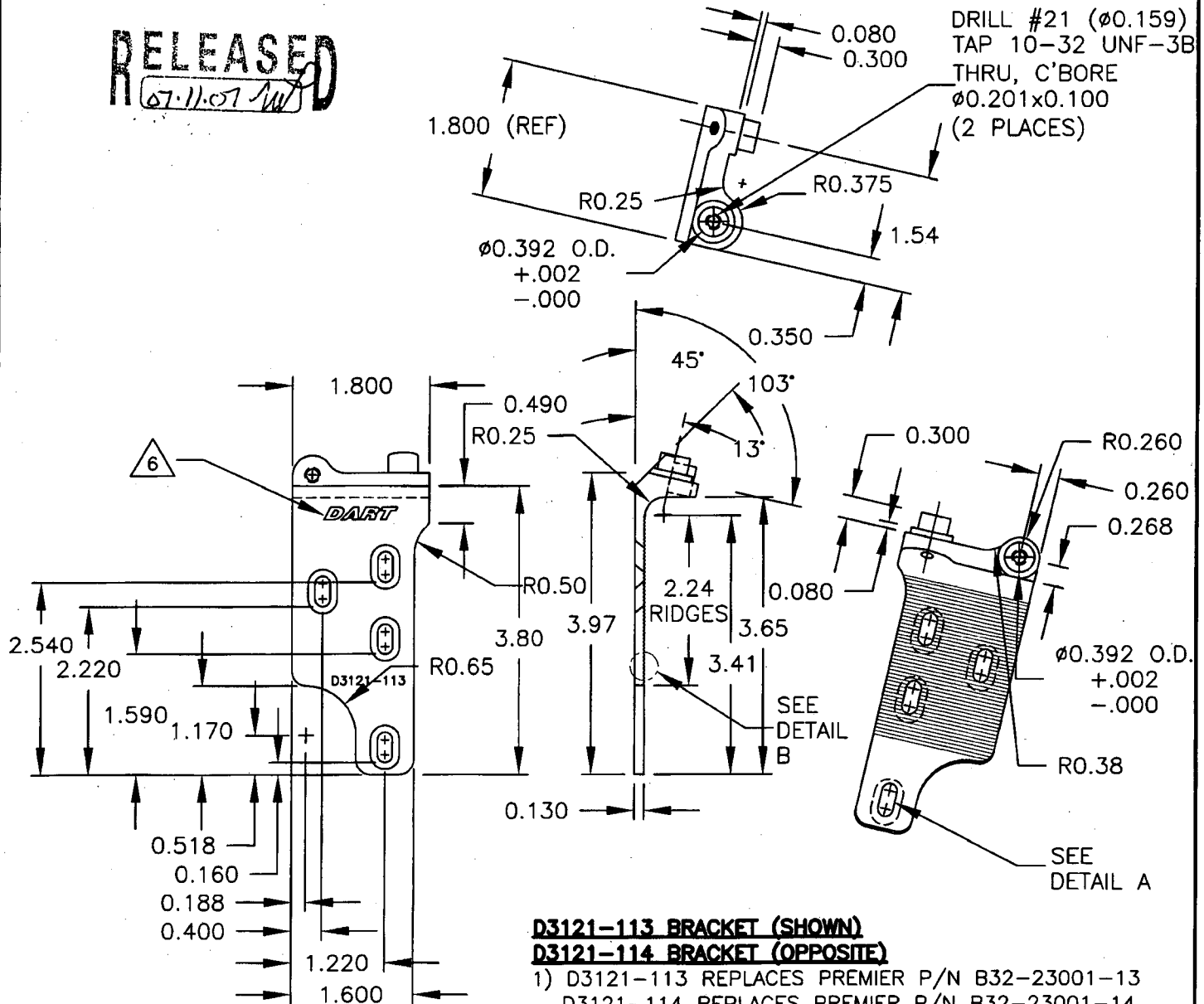
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

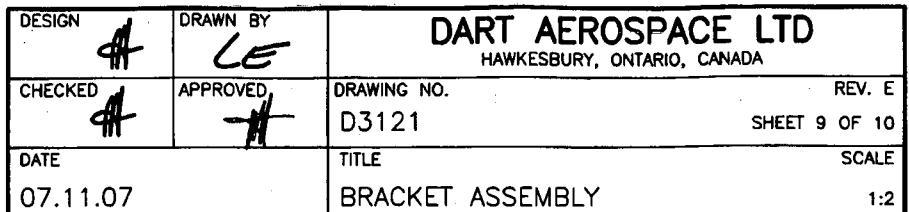
RELEASED
07.11.07 W**D3121-113 BRACKET (SHOWN)****D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

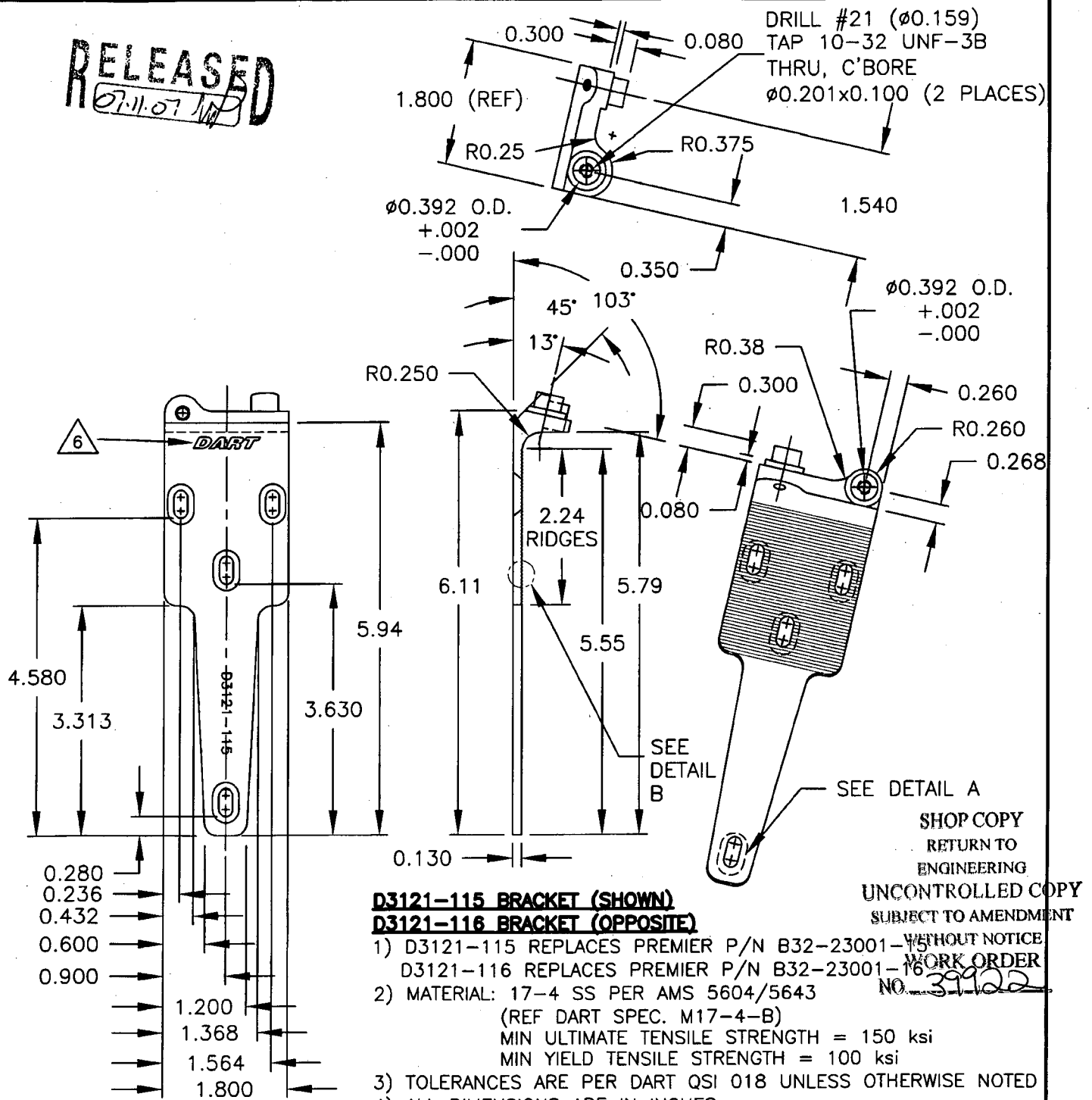
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NO. 39922

D3121-115 BRACKET (SHOWN)
D3121-116 BRACKET (OPPOSITE)

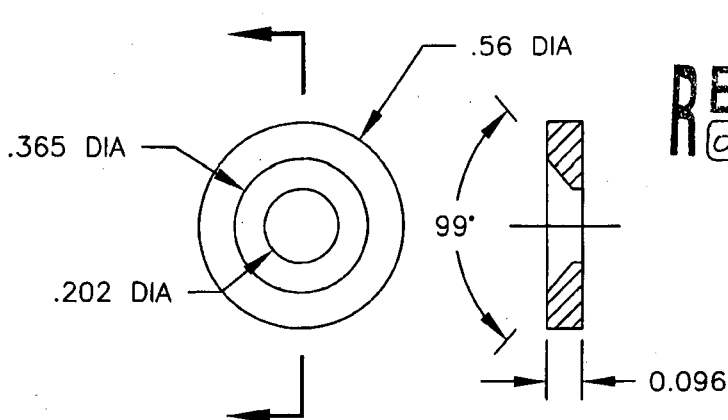
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D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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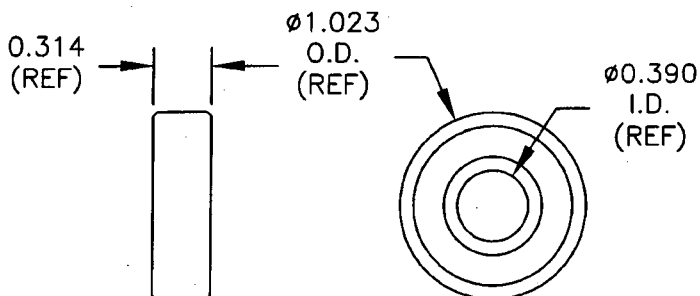
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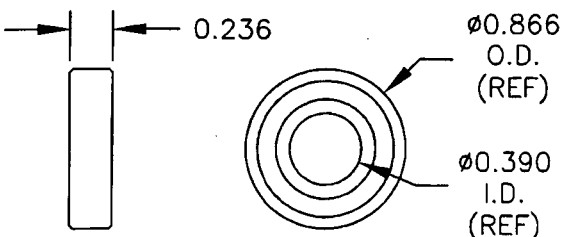
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

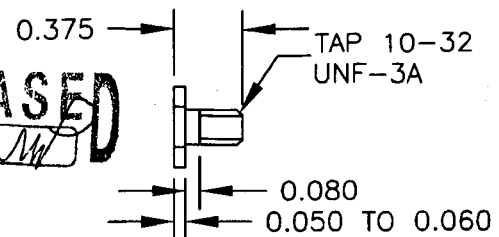
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

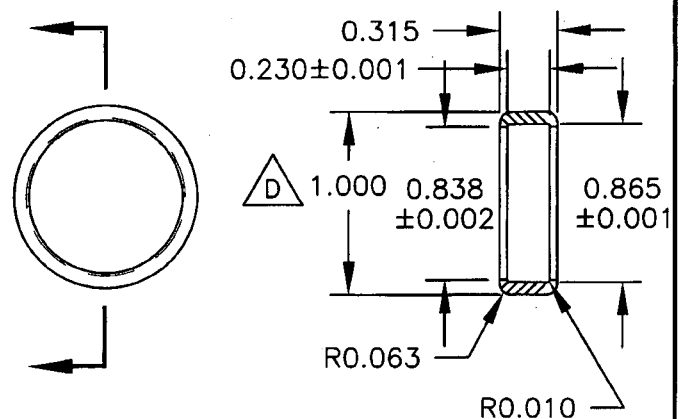
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

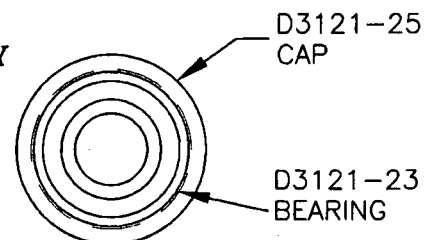
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, 1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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